



Dart Aerospace Ltd.
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U/R

SAD
18.10.03

D4776-3
Job Sheet 184133



Part No: D4776-3

Job Qty: 30 ea

Part Name: Skidtube Clevis



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/3/18

Job Tracking No:

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: URF 18-803 DWG REV D SHEET 2 IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM IPP REV:B
13.09.26 AS PER REV.B DD VERF:JLM IPP REV:C AS PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea	11/2/18	11/2/18	0.00	0.00	Start Up Machining-3		mmml 18/10/29
100	Bandsaw	30 pcs	11/2/18	11/2/18	0.00	0.54	Bandsaw1		"
110	CNC Vertical Machining	30 pcs	11/2/18	11/2/18	0.26	26.09	HAAS1-5		"
120	QC	30 pcs	11/2/18	11/2/18	0.00	0.00	QC2 Machining-3		"
130	QC	30 pcs	11/2/18	11/2/18	0.00	0.00	QC8 Machining-3		18/10/29
140	HandFinish	30 pcs	11/2/18	11/2/18	0.00	0.79	HandFinish1		DR 18/10/30
150	QC	30 pcs	11/2/18	11/2/18	0.00	0.00	QC7-4		18-10-30
160	Powdercoat	30 pcs	11/2/18	11/2/18	0.00	0.37	Powdercoat1		18-10-30
170	QC	30 pcs	11/2/18	11/2/18	0.00	0.00	QC3		DAS 38
180	Packaging	30 pcs	11/2/18	11/2/18	0.00	0.00	Packaging3-2		69 9-89
190	QC21-SA	30 Ea	11/2/18	11/2/18	0.00	0.00	QC21		9-89 DAS 21 NOV 06 2018

Part Op 100 - Cut Blank at 4.400"
Descriptions: 110 - 1-Machine per folio FB168
160 - START TIME: 3:30

TEMP: 320° FINISH: 4.00

M38851

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	11.0100 ft (.367 ea)	90-Start up Operation	5108978=3.91 5099812=7.46

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.500X2.500	11	33	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Skidtube Clevis	4.250Inches ± 0.030	4.280 4.220		
2	Skidtube Clevis	2.250Inches ± 0.030	2.280 2.220		
3	Skidtube Clevis	1.688Inches ± 0.010	1.698 1.678		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

4	Skidtube Clevis	0.880Inches ± 0.030	0.910 0.850	
5	Skidtube Clevis	0.510Inches + 0.010 - 0.000	0.520 0.510	
6	Skidtube Clevis	1.063Inches ± 0.010	1.073 1.053	
7	Skidtube Clevis	1.380Inches ± 0.030	1.410 1.350	
8	Skidtube Clevis	0.190Inches ± 0.030	0.220 0.160	
9	Skidtube Clevis	1.000Inches ± 0.030	1.030 0.970	
10	Skidtube Clevis	0.484Inches + 0.006 - 0.001	0.490 0.483	Diameter
11	Skidtube Clevis	0.500Inches ± 0.030	0.530 0.470	
12	Skidtube Clevis	0.550Inches ± 0.030	0.580 0.520	
13	Skidtube Clevis	3.150Inches ± 0.010	3.160 3.140	
14	Skidtube Clevis	1.130Inches ± 0.030	1.160 1.100	
15	Skidtube Clevis	0.688Inches ± 0.010	0.698 0.678	
16	Skidtube Clevis	0.397Inches + 0.006 - 0.001	0.403 0.396	Diameter
17	Skidtube Clevis	1.813Inches ± 0.010	1.823 1.803	
18	Skidtube Clevis	0.190Inches ± 0.030	0.220 0.160	Radius
19	Skidtube Clevis	0.130Inches ± 0.030	0.160 0.100	Radius
20	Skidtube Clevis	0.440Inches ± 0.030	0.470 0.410	Radius
21	Skidtube Clevis	0.125Inches ± 0.010	0.135 0.115	
22	Skidtube Clevis	0.380Inches ± 0.030	0.410 0.350	
23	Skidtube Clevis	0.750Inches ± 0.030	0.780 0.720	
24	Skidtube Clevis	0.250Inches ± 0.030	0.280 0.220	Radius

DQA: _____ Date: _____

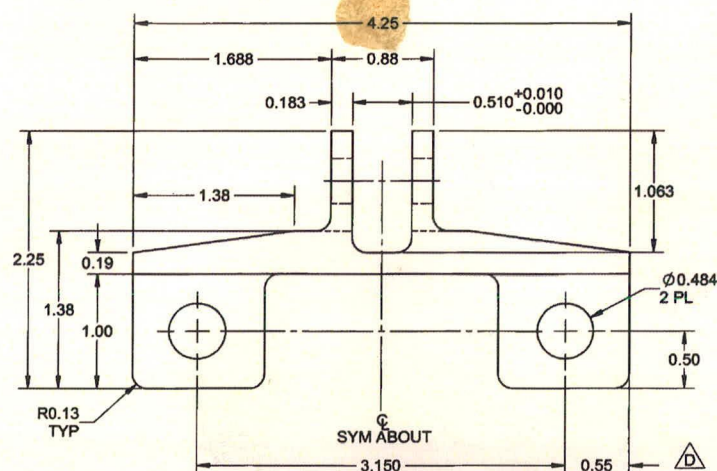
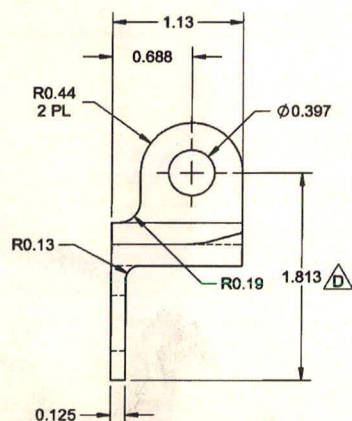
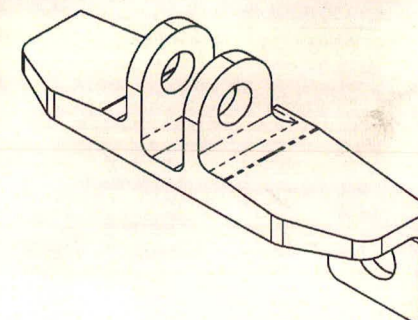
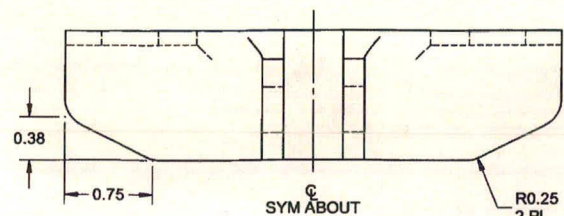
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Work Order update only ☐

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8 7 6 5 4 3 2 1



UNDER REVIEW

URF 18-803 SAD
18.09.12

RELEASED
2014-07-30

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.1
- 7) WEIGHT: 0.18 lbs

D4776-3 SKIDTUBE CLEVIS

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4776	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET STRUT MACHINED PARTS	NTS
DATE	14.07.14	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



Container No: S121639



Part: D4776-3
Job No: 184133
Serial No/Batch: S121639
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

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1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/25/18